



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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RB KIT 407M
Job Sheet 189630



Part No: RB KIT 407M

Job Qty: 1 pcs

Part Name: Spline Measuring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 4/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *Order 3940*

Note: DWG RB KIT 407M REV.D IPP REV A 18.01.25 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD/IPP Rev. C 19.01.24 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	4/8/19	4/8/19	0.00	1.00	Small Fab - 1		
							Small Fab - 2		<i>MLL</i>
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	4/8/19	4/8/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	4/8/19	4/8/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Container No: S162047

Part: RB KIT 407M

Job No: 189630

Serial No/Batch: S162047

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/13/19

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
140	QC 21 - FG	1 pcs	4/8/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

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Part Op **100** - Small Fab - -Print sheet 3 of 5 of the dwg. for labels and cut out. -Place pins in vials with the correct label. -
 Descriptions: Assemble kit.

110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____ - Identify and Stock

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
071600	Vials w/Lids	16 Ea (16 ea)	100-Small Fab - 1	507812
APP-1120-E	Case	1 Ea (1 ea)	100-Small Fab - 1	5155726
RB KIT 407M-01	Gauge Pin .0240" dia.	2 pcs (2 ea)	100-Small Fab - 1	5126910
RB KIT 407M-03	Gauge Pin .0400" dia.	2 pcs (2 ea)	100-Small Fab - 1	5150384
RB KIT 407M-05	Gauge Pin .0540" dia.	2 pcs (2 ea)	100-Small Fab - 1	5128745
RB KIT 407M-07	Gauge Pin .0600" dia.	2 pcs (2 ea)	100-Small Fab - 1	5156697
RB KIT 407M-09	Gauge Pin .0800" dia.	2 pcs (2 ea)	100-Small Fab - 1	5126920
RB KIT 407M-11	Gauge Pin .0960" dia.	2 pcs (2 ea)	100-Small Fab - 1	5156903
RB KIT 407M-13	Gauge Pin .1080" dia.	2 pcs (2 ea)	100-Small Fab - 1	5151997
RB KIT 407M-15	Gauge Pin .1200" dia.	2 pcs (2 ea)	100-Small Fab - 1	5152012
RB KIT 407M-17	Gauge Pin .1440"	2 pcs (2 ea)	100-Small Fab - 1	5131277
RB KIT 407M-19	Gauge Pin .1440"	2 pcs (2 ea)	100-Small Fab - 1	5156817
RB KIT 407M-21	Gauge Pin .1600" dia.	2 pcs (2 ea)	100-Small Fab - 1	5152023
RB KIT 407M-23	Gauge Pin .1600" dia.	2 Ea (2 ea)	100-Small Fab - 1	5052184 5096636
RB KIT 407M-25	Gauge Pin .1728" dia.	2 pcs (2 ea)	100-Small Fab - 1	5156693
RB KIT 407M-27	Gauge Pin .1728" dia.	2 pcs (2 ea)	100-Small Fab - 1	5156830
RB KIT 407M-29	Gauge Pin .1800" dia.	2 Ea (2 ea)	100-Small Fab - 1	5121647
RB KIT 407M-31	Gauge Pin .1920" dia.	2 pcs (2 ea)	100-Small Fab - 1	5156833
RB KIT 407M-35	Labels N/A	1 pcs (1 ea)	100-Small Fab - 1	N/R
RB KIT 407M-39	Bottom Foam (Ethafom 220, Black, 2.58 x 4.83 x 7.34) use with case APP-1120-E	1 Ea (1 ea)	100-Small Fab - 1	5155728
RB KIT 407M-41	Top Foam (Ethafom 220, Black, 0.45 x 4.79 x 7.26) use with case APP-1120-E	1 Ea (1 ea)	100-Small Fab - 1	5155727
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Small Fab - 1	304040

8623

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	071600	16	4,680	0
	APP-1120-E	1	6	0
	RB KIT 407M-01	2	8	0
	RB KIT 407M-03	2	8	0
	RB KIT 407M-05	2	18	0
	RB KIT 407M-07	2	1	0
	RB KIT 407M-09	2	8	0
	RB KIT 407M-11	2	1	0
	RB KIT 407M-13	2	4	0
	RB KIT 407M-15	2	3	0
	RB KIT 407M-17	2	20	0
	RB KIT 407M-19	2	1	0
	RB KIT 407M-21	2	2	0
	RB KIT 407M-23	2	41	0
	RB KIT 407M-25	2	4	0
	RB KIT 407M-27	2	6	0
	RB KIT 407M-29	2	6	0
	RB KIT 407M-31	2	1	0
	RB KIT 407M-35	1	0	0
	RB KIT 407M-39	1	1	0
	RB KIT 407M-41	1	1	0
	RB41011	1	474	0

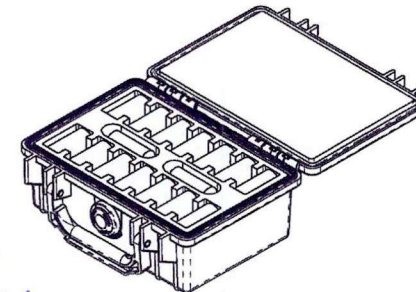
Part Specifications

Specifications could not be found.

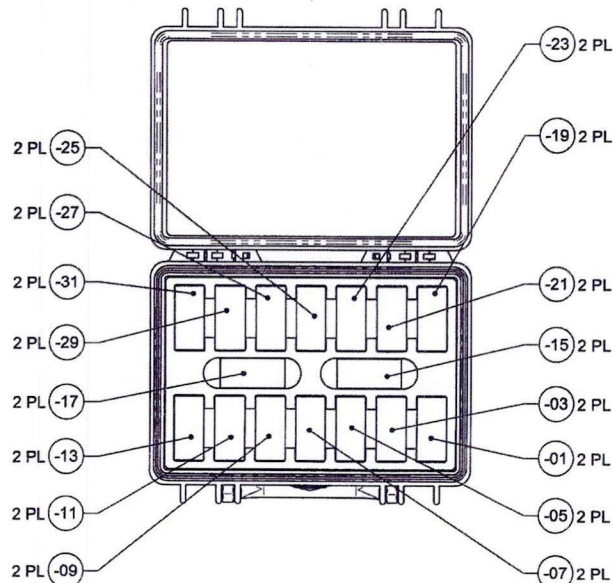
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ITEM #	QTY	PART #	PART TITLE
-01	2	RB KIT 407M-01	Ø.0240, CLASS X PLUG NO-GO GAUGE
-03	2	RB KIT 407M-03	Ø.0400, CLASS X PLUG NO-GO GAUGE
-05	2	RB KIT 407M-05	Ø.0540, CLASS X PLUG NO-GO GAUGE
-07	2	RB KIT 407M-07	Ø.0800, CLASS X PLUG NO-GO GAUGE
-09	2	RB KIT 407M-09	Ø.0800, CLASS X PLUG NO-GO GAUGE
-11	2	RB KIT 407M-11	Ø.0960, CLASS X PLUG NO-GO GAUGE
-13	2	RB KIT 407M-13	Ø.1080, CLASS X PLUG NO-GO GAUGE
-15	2	RB KIT 407M-15	Ø.1200, CLASS X PLUG NO-GO GAUGE
-17	2	RB KIT 407M-17	Ø.1440, CLASS X PLUG NO-GO GAUGE
-19	2	RB KIT 407M-19	Ø.1440, CLASS X PLUG NO-GO GAUGE
-21	2	RB KIT 407M-21	Ø.1600, CLASS X PLUG NO-GO GAUGE
-23	2	RB KIT 407M-23	Ø.1600, CLASS X PLUG NO-GO GAUGE
-25	2	RB KIT 407M-25	Ø.1728, CLASS X PLUG NO-GO GAUGE
-27	2	RB KIT 407M-27	Ø.1728, CLASS X PLUG NO-GO GAUGE
-29	2	RB KIT 407M-29	Ø.1800, CLASS X PLUG NO-GO GAUGE
-31	2	RB KIT 407M-31	Ø.1920, CLASS X PLUG NO-GO GAUGE
-35	1	RB KIT 407M-35	LABELS
-37	1	RB KIT 407M-37	SPLINE MEASURING KIT PACKAGING ASSY
42	16	LaContainer#071600 OR EQUIV.	CLEAR STYRENE VIAL WITH LID 5/8" ID X 1-5/8" LG

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189630 hvs
1901-29



RB KIT 407M SPLINE MEASURING KIT



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) PLACE GAUGE PINS INTO SMALL SEALABLE PLASTIC BAG WITH SMALL AMOUNT OF LPS #2 OIL TO PREVENT CORROSION THEN PLACE INTO ITEM 42
- 8) CUT ITEM -35 AND INSERT INTO CORRESPONDING VIAL WITH GAUGE PINS AS SHOWN

	UPDATED DRAWING TEMPLATE			
D	ITEM -37 WAS HARD CASE ON LAST REVISION IS NOW PACKAGING ASSEMBLY ITEM 42 WAS ITEM -33 NOTES UPDATED		19-516	MBB
	-01 THRU -31 ADDED NOTES. UPDATED TABLE 1 (GAUGE PIN DIMENSIONS). DIMENSION B TOLERANCE ADDED			
	-35 ADDED NOTES 1 TO 7			
	-39 ADDED NOTES 1 TO 8. DIMENSION R.13 WAS CHAMFER .50X45°			
	-41 ADDED NOTES 1 TO 9. DIM WAS 7.26 IS 7.38. DIM WAS 4.79 IS 5.00. DIM WAS 0.45 IS 0.50. ADDED DIMENSION R.13			
C	ADDRESS ON ITEM -35 CHANGED TO HAWKESBURY ADDRESS. REMOVED SPECIFIC SUPPLIER INFO		18-537	KT
2	-01 THRU -31 ADDED GAUGE PIN DIMENSIONS TABLE. -39 CH'D DIM WAS 64X R.06 IS 56X R.06. CH'D DEPTH WAS 16X .44 IS $\sqrt{.78}$. ADDED FINGER PULLS. -41 CH'D MATERIAL WAS C200 EGGSHELL, BLACK IS ETHAFOAM 220, BLACK			RJC
1	RELEASED FOR PRODUCTION.			RJC
REV.	DESCRIPTION		ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB KIT 407M TITLE SPLINE MEASURING KIT SCALE NTS REV. I SHEET 1 OF 6		
DRAWN	MBB			
CHECKED	KPT			
MFG. APPR.	DP			
APPROVED	VIT	DATE 1/17/2019		
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					